

Date: Thursday, 10/11/2007 2:55:30 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: INLET ADAPTER
Job Number	: 35144		
Estimate Number	: 12160		
P.O. Number	:	Part Number	: D3479041
This Issue	: 10/11/2007 S.O. No. :	Drawing Number	: D3479 UNDER REVIEW
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 34070	Material	:
Written By	:	Due Date	: 10/30/2007 Qty: 4 Um: Each
Checked & Approved By	:		
Comment	: Est Rev: A New Issue 06-02-02 JLM		

OK PER
HALL OPS.
10/10/12

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D34791	TUBE
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3479-1	Tube	B 34087

mf

2.0	D34795	TAB, 81 DEGREE
-----	--------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

X	Qty	Part Number	Description	Batch
	1	D3479-5	Flange	B 35163

mf

3.0	D34793	TAB, 99 DEGREE
-----	--------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

X	Qty	Part Number	Description	Batch
	1	D3479-3	Tab	B 35162

mf

4.0	D34797	FLANGE PLATE
-----	--------	--------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

X	Qty	Part Number	Description	Batch
	1	D3479-7	Tab	B 34402

mf 07-10-29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/11/2007 2:55:30 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INLET ADAPTER

Job Number: 35144

Part Number: D3479041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3479

2-Spot Weld as per Dwg D3479 and Dart QSI 018

WF 07-10-29.

(4)

6.0

QC11

VISUAL INSPECTION OF SPOT WELDING



Comment: VISUAL INSPECTION OF SPOT WELDING

SB 07/10/31

(4)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/10/31

(4)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with a permanent fine point marker and Stock

Location: SI103

(x4)

07/10/31

NS

U

9.0

QC21

FINAL INSPECTION/W/O RELEASE



07.10.31

HA

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07-10-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

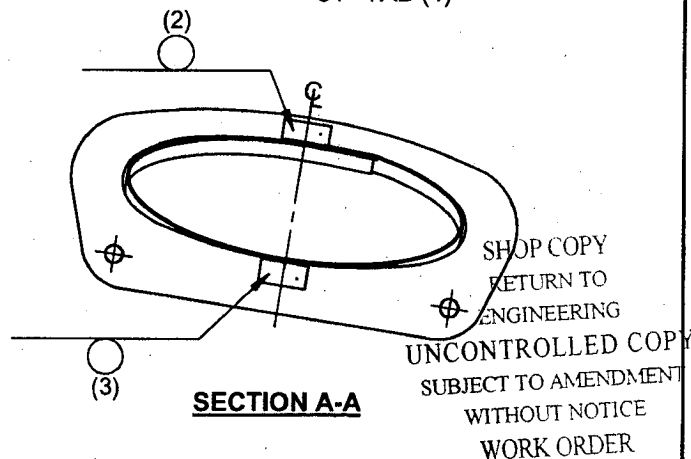
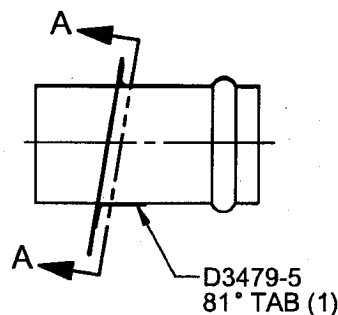
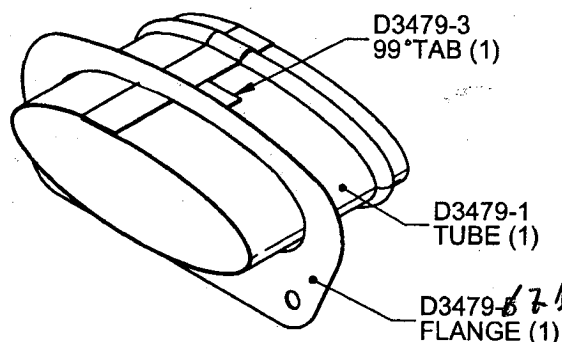
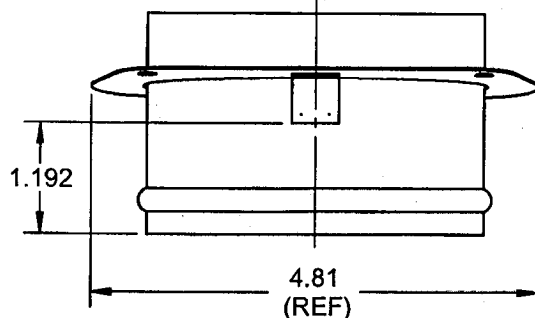
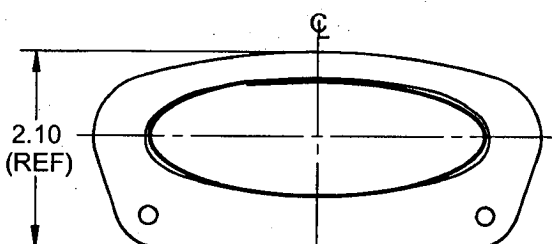
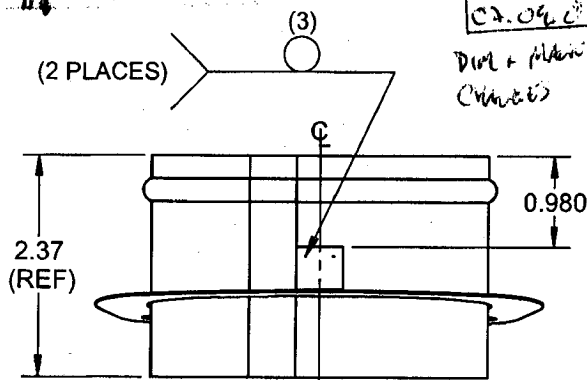
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #3	DRAWN BY #3	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3479	REV. A SHEET 1 OF 4
DATE 06.01.19		TITLE INLET ADAPTER	SCALE 1:2
A	06.01.19	NEW ISSUE	

06 04.03

UNDER REVIEWCA. 04.02.19
DIP + MANUFACTURING
(CHECK)**D3479-041 INLET ADAPTER****NOTES:**

- 1) SPOT WELD PER DART QSI 018
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3479-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3479-041	INLET ADAPTER
1	D3479-1	TUBE
1	D3479-3	99 DEGREE TAB
1	D3479-5	81 DEGREE TAB
1	D3479-7	FLANGE

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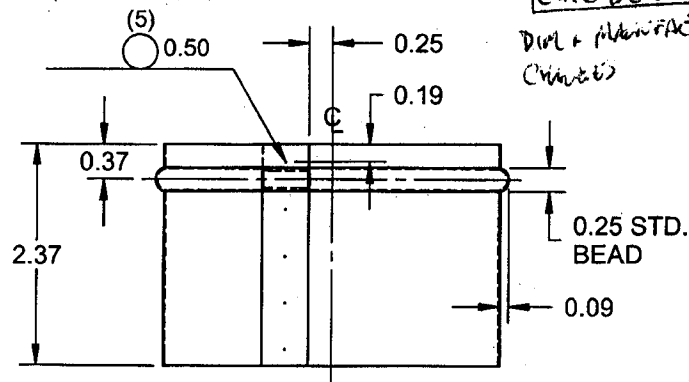
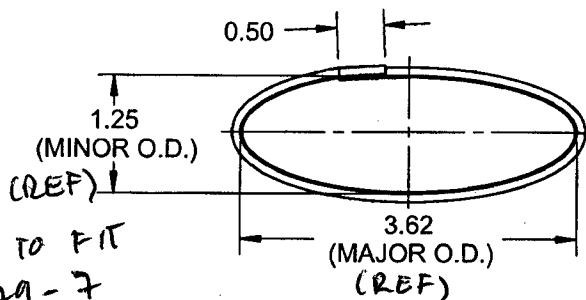
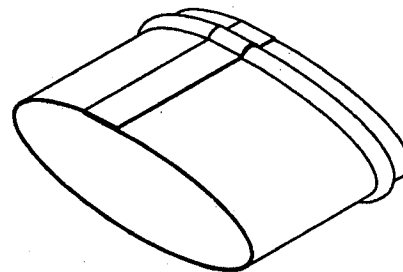
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DATE 06.01.19		TITLE INLET ADAPTER	SCALE 1:2

UNDER REVIEW

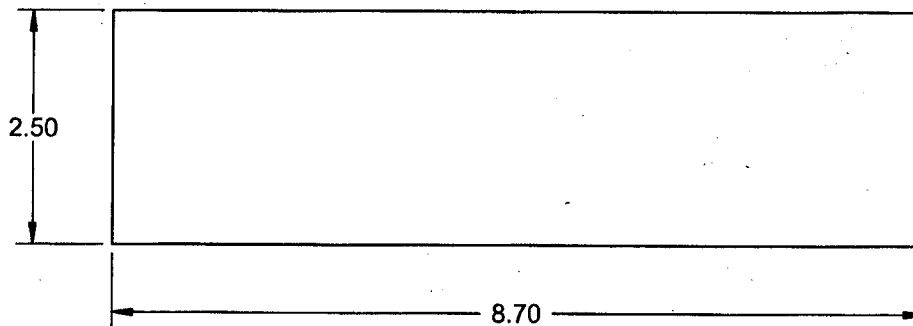
06.04.03

Dart + fabrication
(Chin & Co)

Form to FIT

D3479-7

07.10.12

D3479-1 TUBE**D3479-1F FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 018
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

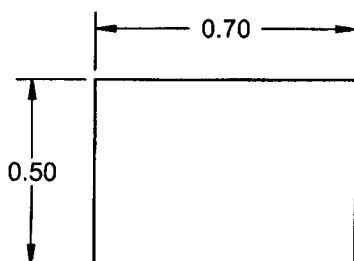
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DATE 06.01.19		TITLE ADAPTER INLET	SCALE 2:1



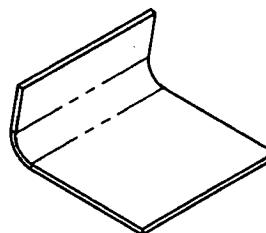
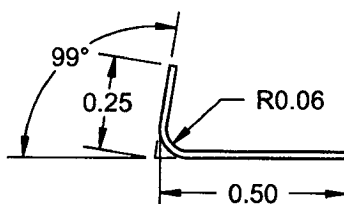
UNDER REVIEW

[Signature]
02.04.03
Diel + Manufacturing
CNC

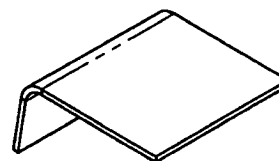
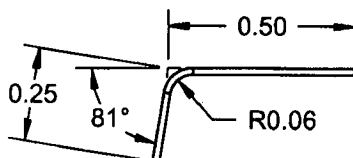
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06.04.03

D3479-3F FLAT PATTERN

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)



D3479-3 99 DEGREE TAB (MAKE FROM D3479-3F FLAT PATTERN)



D3479-5 81 DEGREE TAB (MAKE FROM D3479-3F FLAT PATTERN)

NOTES:

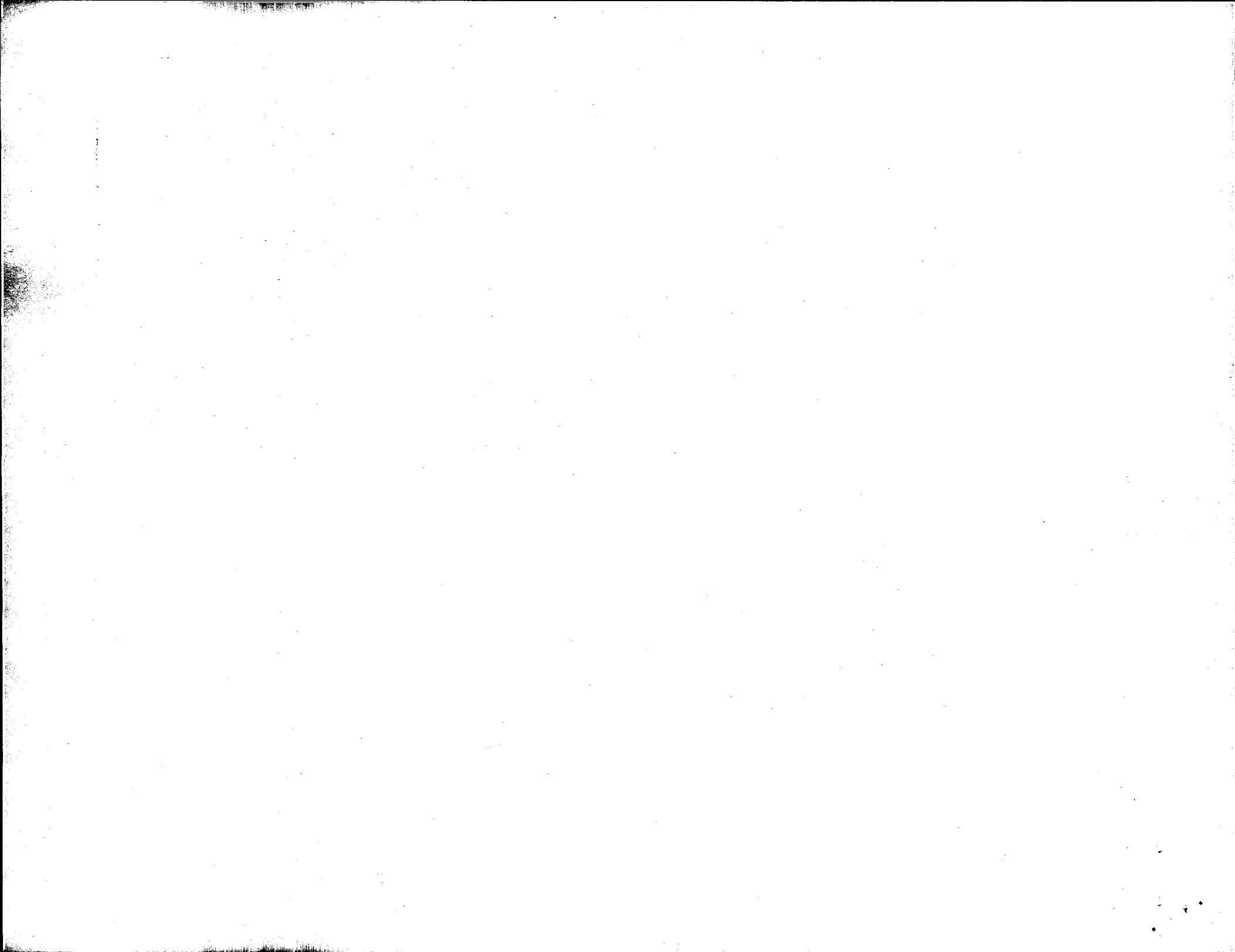
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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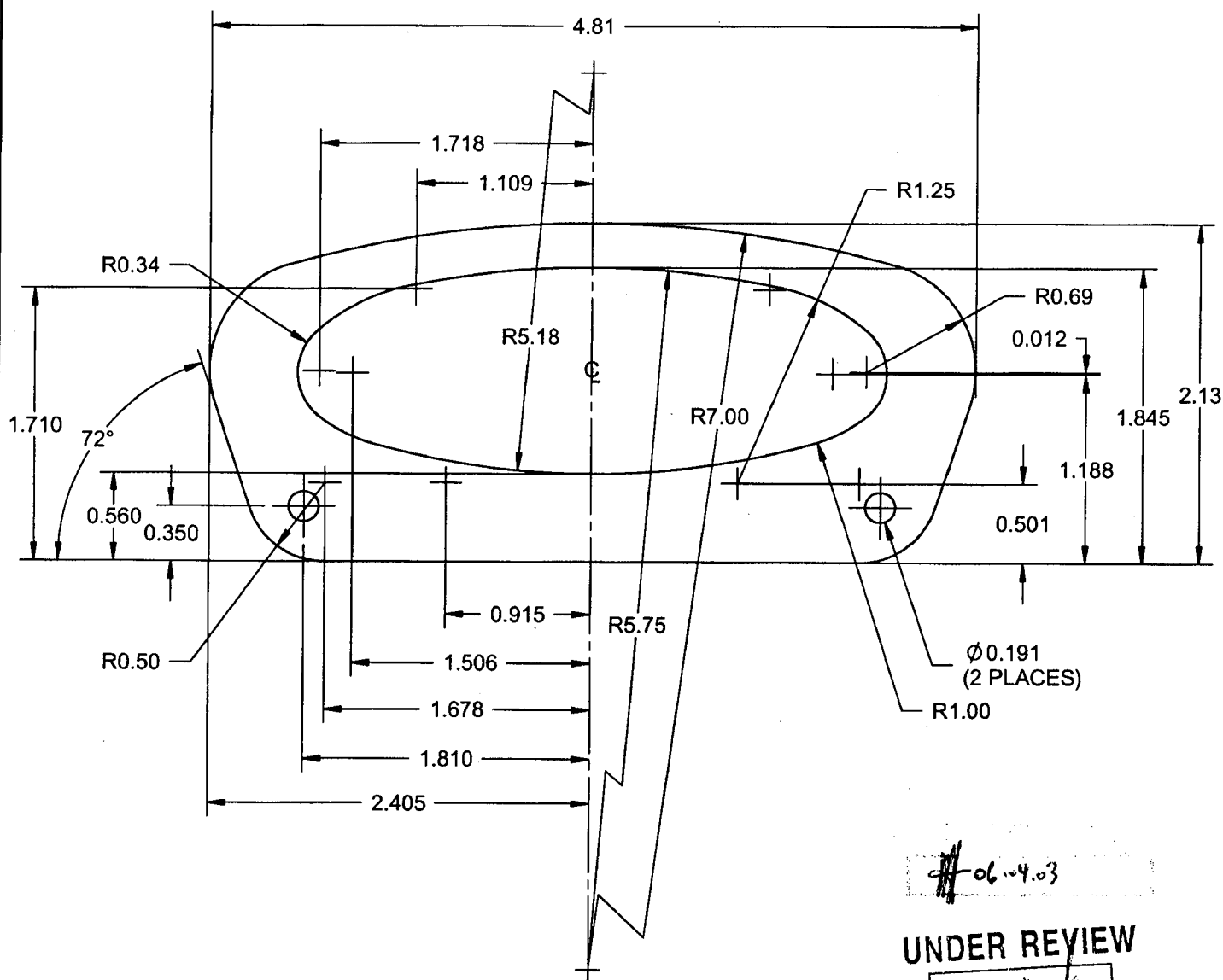
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DATE 06.01.19	TITLE ADAPTER INLET		SCALE 1:1

**D3479-7 FLANGE PLATE****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

UNDER REVIEW*[Signature]**Dial + Manufacturing*
Chavez

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SPOT WELD TEST RECORD
AMS-W-6858A
CLASS 'C'

TEST NO#: 36

EMPLOYEE: Melvin Fautley

PART NUMBER: D 3479-041

JOB NUMBER: B 35744

MATERIAL TYPE: 304L

MATERIAL THICKNESS: .012

GROUP SPECIFICATION

- ☐ Group 1: Aluminum & magnesium
☐ Group 2: Iron; nickel; cobalt
☒ Group 3: Titanium

TEST RESULTS

	PASS	FAIL
VISUAL:	[/]	[]
PENETRATION:	[/]	[]
PULL STRENGTH:	[/]	[] PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 07/02/20
QUALIFIER: SIB